

Date: Friday, 05/09/2008 10:10:15 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	03.250 SUPPORT
Job Number :	41870		
Estimate Number :	10387		
P.O. Number :		Part Number :	D29401
This Issue :	05/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2940 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	41536	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	12/09/2008
Written By :		Qty:	20
		Um:	Each
Checked & Approved By :	JLD 08.9.05		
Comment :	Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM est E 08.03.19 Re-format Ec verified by DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK081	D2940-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2940-1 TURNING DETAIL

Batch: **B42375**

DJP 08/10/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS

1- Machine as per Folio FA079

2- Tumble & Deburr

DJP 08/10/08

SS 08/10/09

(20)

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SS 08/10/09

(20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/10/14

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
400
8:30

M-L 08/10/15

(20x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:10:15 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 41870

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

RT 08-10-27 (x20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SO 08/10/24 (x20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Y tube assy

RT 08 10 27 (x20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/27

Job Completion



MF 08-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41870
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.150	.149	.149	.150
AD	3.510	3.530		3.525	3.525	3.525	3.525	3.520
AE	1.633	1.673		1.654	1.654	1.654	1.654	1.654
AF	1.493	1.513		1.500	1.500	1.493	1.505	1.500
AG	0.040	0.060		.050	.050	.050	.050	.050
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.144	.145	.150	.150	.150
AJ	2.518	2.538		2.523	2.523	2.520	2.520	2.520
AK	0.040	0.060		.047	.047	.050	.050	.050
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.155	.155	.155	.155	.150
AN	0.350	0.450		.417	.417	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.153	.153	.153	.150	.150
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.262	.262	.262	.262	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.125	4.125	4.120	4.120	4.120
AV								
AW								
Accept/Reject								

Measured by: JS	Date: 08/10/09
Audited by: J.L.	Date: 08/10/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41870
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6x	7x	8x	9x	10x
HAAS Section								
AA	0.240	0.260		.250	.250	.250	0.250	0.250
AB	0.490	0.510		.500	.500	.500	0.500	0.500
AC	0.140	0.160		.150	.150	.150	0.150	0.150
AD	3.510	3.530		3.520	3.520	3.520	3.520	3.520
AE	1.633	1.673		1.650	1.650	1.650	1.661	1.662
AF	1.493	1.513		1.500	1.500	1.500	1.505	1.505
AG	0.040	0.060		.050	.050	.050	0.050	0.050
AH	0.188	0.193		.188	.188	.188	0.189	0.189
AI	0.140	0.160		.150	.150	.150	0.150	0.150
AJ	2.518	2.538		2.520	2.520	2.520	2.530	2.530
AK	0.040	0.060		.050	.050	.050	0.050	0.050
AL	0.010	0.020		.015	.015	.015	0.015	0.015
AM	0.140	0.160		.150	.150	.150	0.145	0.145
AN	0.350	0.450		.400	.400	.420	0.380	0.380
AO	0.240	0.260		.250	.250	.250	0.250	0.250
AP	0.150	0.170		.150	.160	.160	0.1565	0.1565
AQ	0.053	0.073		.063	.063	.063	0.055	0.055
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	0.263	0.263
AT	0.053	0.073		.063	.063	.063	0.063	0.063
AU	4.118	4.138		4.120	4.120	4.120	4.129	4.130
AV								
AW								
Accept/Reject								

Measured by: <i>SS</i>	Date: 08/10/10
Audited by: <i>SL</i>	Date: 08/10/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 41870
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	110	12	13	14	15
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.153	0.153	0.153	0.154	0.153
AD	3.510	3.530		3.524	3.524	3.525	3.525	3.522
AE	1.633	1.673		1.661	1.659	1.660	1.660	1.660
AF	1.493	1.513		1.505	1.503	1.504	1.505	1.5045
AG	0.040	0.060		0.049	0.049	0.049	0.048	0.049
AH	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AI	0.140	0.160		0.151	0.149	0.145	0.145	0.149
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020	-0.015	0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.147	0.145	0.145	0.145	0.145
AN	0.350	0.450	-0.380	0.380	0.380	0.380	0.380	0.380
AO	0.240	0.260	-0.250	0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.157	0.156	0.156	0.155	0.155
AQ	0.053	0.073	-0.055	0.055	0.055	0.055	0.055	0.055
AR	101.64	105.64	-103.64	103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267	-0.263	0.263	0.263	0.263	0.263	0.263
AT	0.053	0.073	-0.063	0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.130	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

Measured by: DIP	Date: 08/10/11
Audited by: O.J.L	Date: 08/10/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41870
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.152	0.150	0.151	0.151	0.151
AD	3.510	3.530		3.524	3.522	3.522	3.523	3.523
AE	1.633	1.673		1.659	1.661	1.660	1.661	1.661
AF	1.493	1.513		1.503	1.505	1.504	1.505	1.505
AG	0.040	0.060		0.049	0.050	0.050	0.050	0.050
AH	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AI	0.140	0.160		0.144	0.149	0.149	0.149	0.149
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.153	0.145	0.143	0.144	0.144
AN	0.350	0.450		0.380	0.380	0.380	0.380	0.380
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.156	0.156	0.156	0.157	0.156
AQ	0.053	0.073		0.055	0.055	0.055	0.055	0.055
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.263	0.263	0.263	0.263	0.263
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.130	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

Measured by: DTP	Date: 08/10/11
Audited by: J.L	Date: 08/10/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

R0.063
(TYP ALL AROUND
INSIDE EDGE)

R103.64±2 -
(THIS EDGE ONLY)

SECTION B-B
SCALE 1:1


TO
CENTER

SECTION A-A
TOOLING HOLE DETAIL
SCALE 1:1

[illegible]

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN	<i>qp</i>	DRAWN BY <i>ph</i>	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2940	
DATE 07.03.16	TITLE Ø3.250 SUPPORT		REV. SHEET 1 OF 1 SCALE

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DART AEROSPACE LTD

DART DART AEROSPACE LTD.
HANWICKSBURY, ONTARIO, CANADA

DRAWING NO.	REV. 8
D3040	SHEET 1 OF 25

D2940	SHEET 1 OF
TITLE	SCALE

Ø3.250 SUPPORT 1:

1:2

NO. 41870 WORK ORDER